



Dart Aerospace Ltd.
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003894

D044-717-011
Job Sheet 170783

Part No: D044-717-011

Job Qty: 2 ea

Part Name: R44 Cold Weather Baffle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/14/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV N/A IPP Rev:B Removed Manufacturing 05-12-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup	Run	Workcenter / Supplier			
90	Start up Operation	2 Ea		2/14/18	0.00	0.00	Start Up Stores/Pkg-1			JUN 15 2018
110	Packaging	2 pcs		2/14/18	0.00	0.00	Packaging1-1			JUN 15 2018
120	QC	2 pcs		2/14/18	0.00	0.00	QC4			JRB
130	Packaging	2 pcs		2/14/18	0.00	0.00	Packaging3-1			JRB
135	DC	2 pcs		2/14/18	0.00	0.00	DC			20
140	QC21-FG	2 Ea		2/14/18	0.00	0.00	QC21			18-06-19

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP D044-717-011 Location: FG027

135 - Photocopy bluefile and create labels per PPP D044-717-011CHG001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN526C1032R7	Screw	16 Ea (8 ea)	90-Start up Operation	FM128403-4
D3276-041	Baffle Assembly LH	2 Ea (1 ea)	90-Start up Operation	3041359
D3276-042	Baffle Assembly RH	2 Ea (1 ea)	90-Start up Operation	3041343
D3383-1	Placard	2 Ea (1 ea)	90-Start up Operation	F139593
MS20426AD3-4	Rivet	32 Ea (16 ea)	90-Start up Operation	FM134294
MS21059L3	Nut Plate	16 Ea (8 ea)	90-Start up Operation	5079114

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN526C1032R7	16	56	0
	D3276-041	2	3	0
	D3276-042	2	3	0
	D3383-1	2	2	0
	MS20426AD3-4	32	2,894	0
	MS21059L3	16	218	0



Container No: S081489



Part: D044-717-011

Job No: 170783

Serial No/Batch: S081489

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 06/15/18

125-0

8AC
TS
125-0

Part Specifications

Specifications could not be found.

Plex 6/15/18 6:41 AM dart.quirion.sonia

CHAPTER 53 – FUSELAGE (53-00-00)**53.1 COLD WEATHER BAFFLE KIT REMOVAL**

The Dart D044-717-011 Cold Weather Baffle Kit should be removed as follows:

- 53.1.1 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-041 Baffle Assembly to the LH inlet. Remove the baffle assembly.
- 53.1.2 Unfasten the qty(4) AN526C1032-7 screws securing the D3276-042 Baffle Assembly to the RH inlet. Remove the baffle assembly.
- 53.1.3 If removing because temperatures are above -10°C (14°F), plug all nut plates with the AN526C1032-7 screws.

53.2 COLD WEATHER BAFFLE KIT REINSTALLATION

The Dart D044-717-011 Cold Weather Baffle Kit should be reinstalled as follows:

- 53.2.1 Locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 0-1 so that holes in baffle line up with nut plates that have already been installed in airframe. Install using qty(4) AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 53.2.2 Repeat installation for RH side using D3276-042 Baffle Assembly.

53.3 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kg

53.4 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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